

Work Order ID 82774

Monday, April 09, 2012 3:18:24 PM

82774

Ship April 12th Page 1

Item ID: D3115-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 4/9/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/12/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MF Date: 12-04-09 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3115

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3115 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

120

QC

Memo

0.00

Quality Control


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/4/10	#140	change step to QCF inspection		12/04/12			J 12/4/10	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 82774***82774***

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Item Name: Bracket

Start Date: 4/9/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/12/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6 ϕ 12-4-10.

170

Identify as per dwg & Stock Location 526

0.00

170

Packaging

Memo

0.00

Packaging

6x SP 12-04-10.

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/04/10

M20110

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, April 09, 2012 3:18:23 PM

Page 1

Work Order ID: 82774

Parent Item: D3115-1

Parent Item Name: Bracket

Start Date: 4/9/2012

Required Date: 4/12/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A02.05.09New IssueNG
IPP Rev:B 07-12-06 now water jet DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	409.4000	0.0223	0.1408421			

Location

Loc Qty

Loc Code

MAT022

409.4

119916

169.4

121197

240

⑥

49916

Jim / m /
12-4-9.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

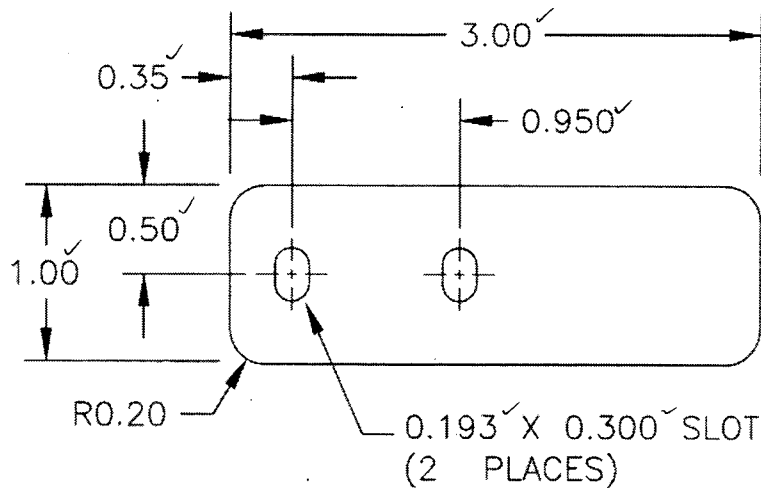
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DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3115	SHEET 1 OF 1
DATE	04.10.18	TITLE	BRACKET	SCALE	1:1
A	02.04.12	NEW ISSUE			
B	04.10.18	ADD PART MARKING			

RELEASED
04.11.23



D3115-1 BRACKET

#82 774

NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-233
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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